

B117071

Work Order ID 117071

647.0113

B117071

\*117071\*

Page 1

April-24-14 9:15:11 AM

Item ID: 647.0113 647.0113 REV-A1 Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Strut Doubler

Start Date: 4/23/14 Start Qty: 12.00 \*12\*

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 12.00 \*12\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 140428 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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647.0100	A1
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110

0.00

\*110\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

(12)

DAS  
46  
9-89

14/08/23

120

0.00

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

(12)

DAS  
46  
9-89

14/08/23

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Work Order update only ☐

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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April-24-14 9:15:11 AM

Page 3

```
Setup  Start  *NS1*
      Stop   *NS2*
```

\*12\*

**Cust Item ID:**  
**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run	Start	*NR1*
	Stop	*NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

**\*160\***

OC

## Memo

0.00

## Quality Control

CCK80

Identify as per dwg & Stock Location:

0.00

**\*190\***

## Packaging

## Memo

0.00

## Packaging

\*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV\*\*\*

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

OC

## Memo

0.00

## Quality Control

12

38  
9-89 14-9-9

12x 14-9-9.

**DAS**  
**26**  
**9-89**

MLJ 14-09-10

mf  
14-9-10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_ Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Process									
Supplier									
Training									
Transport									
Unapproved									

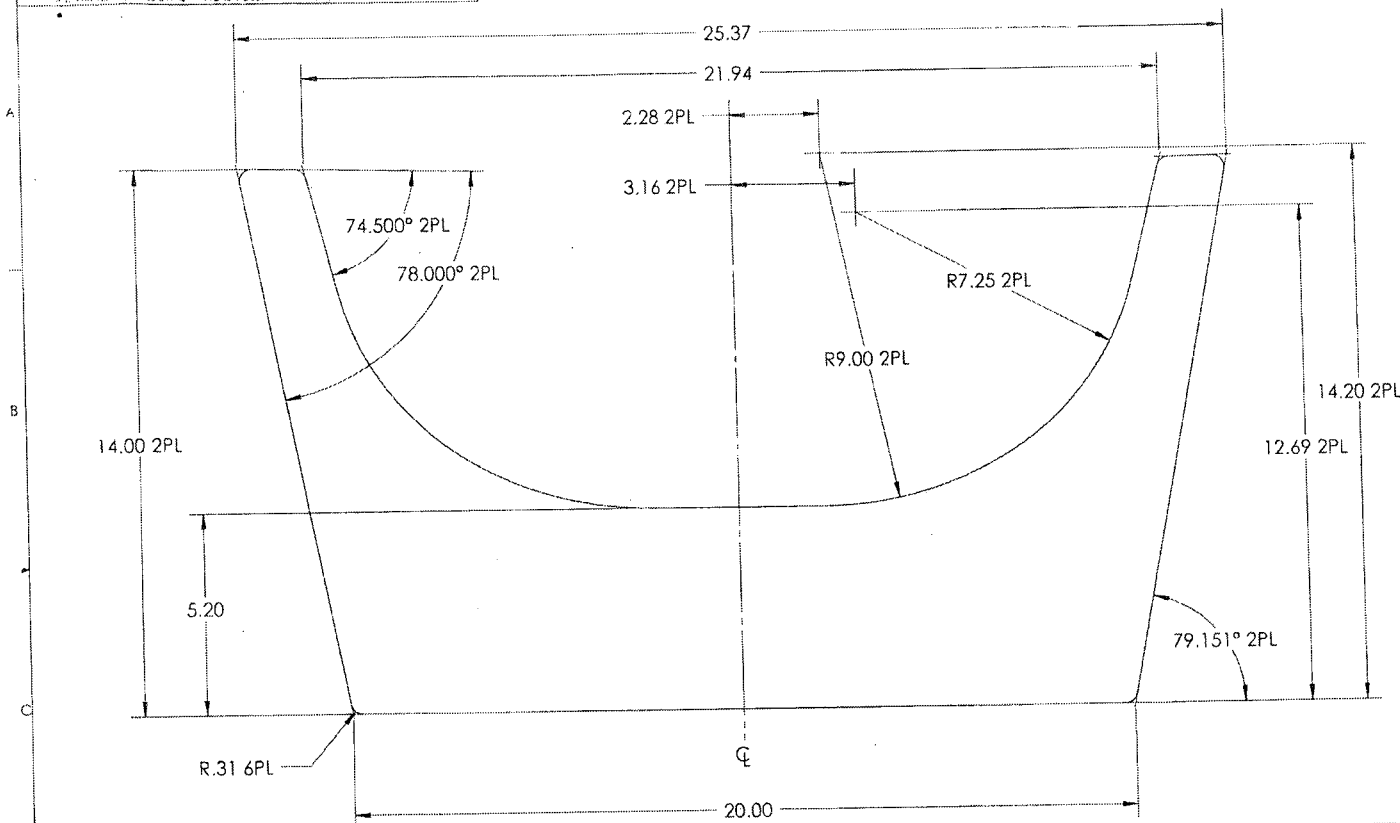
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
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<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



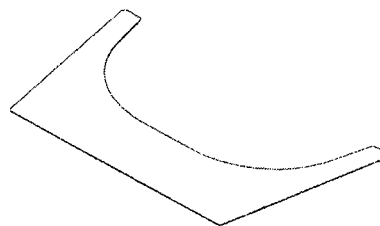
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REV	DESCRIPTION	DATE	APPROVED
1	LAST PRELIMINARY REVISION		W/C
2	INITIAL RELEASE		P. BRAY
3	INCORPORATED REVISIONS		P. BRAY



# NOTES:

- MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
- DEBURR AND BREAK ALL SHARP EDGES.
- IDENTIFY IAW MPP-120.
- MATERIAL: 304 SS IAW AMS 5643.
- FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



647.0110

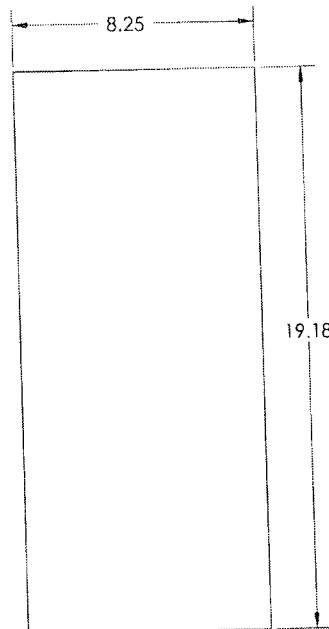
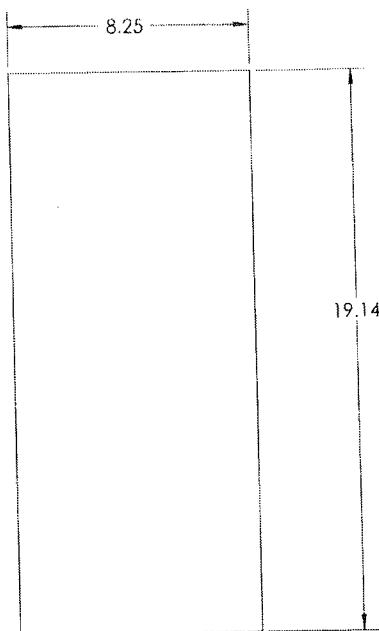
UNINCORPORATED ECN(S)

03985

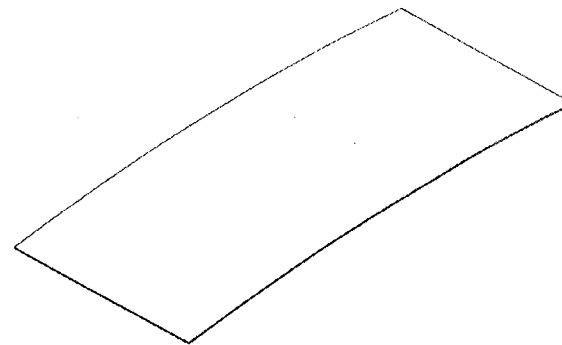
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	647.0115	CLIP	△	△
	647.0114	CLIP	△	△
	647.0113	STRUT DOUBLER	△	△
	647.0112	STRUT BRACKET	△	△
	647.0111	PANEL	△	△
	647.0110	ROOF DOUBLER	△	△
PARTS LIST				
APICAL INDUSTRIES				
2608 TEMPLE HEIGHTS DR.				
OCEANSIDE, CA. 92056-3512 (760) 724-5300				
SHEETMETAL				
QTY	647.0110	DESCRIPTION	647.0100	REV
646.9500	647.0110	ROOF DOUBLER	647.0100	A
NEXT ASSY (S)		SCALE: NONE		
646.9500		SHEET 1 OF 4		



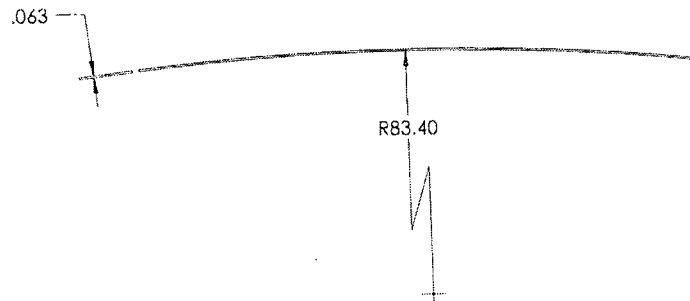
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FLAT PATTERN



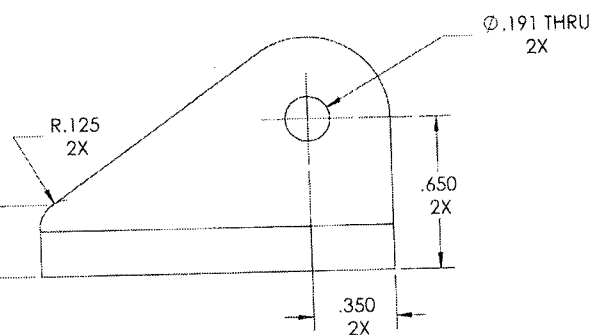
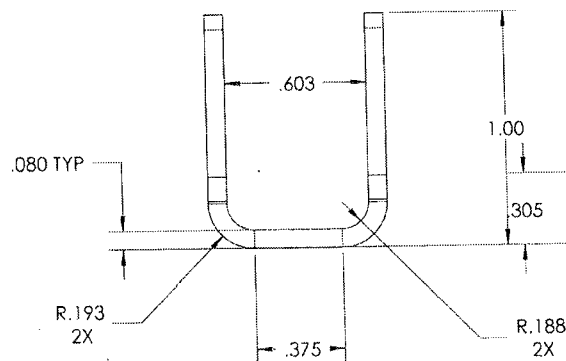
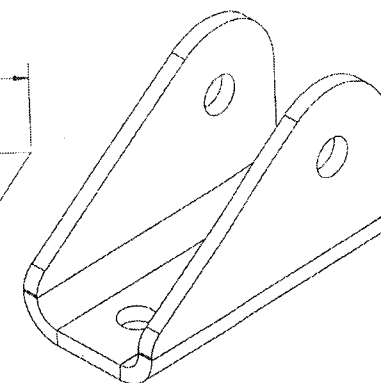
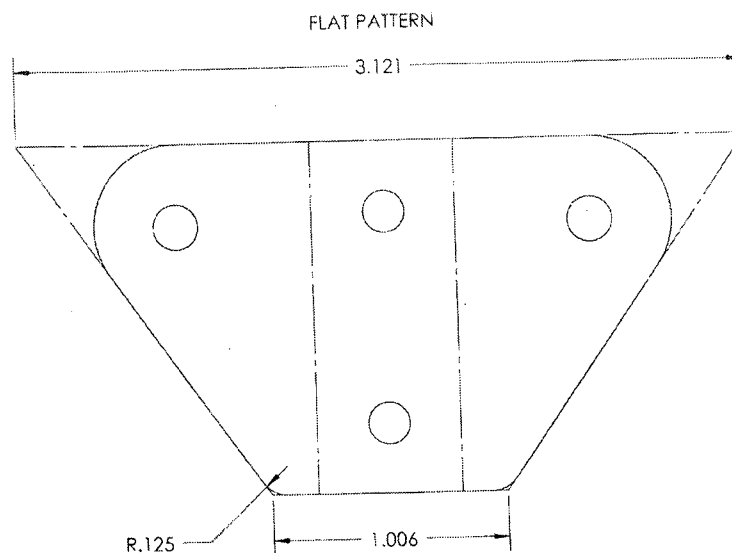
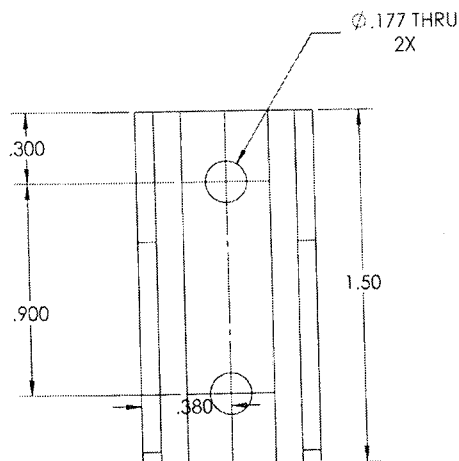
647.0111



ORIGINAL DATE		DESIGN	
DATE/ISSUE		DESIGNER	
DRAWN BY		CHECKED BY	
F. ROSANO		R. BRAND	
DRAWING APPROVAL		DATE	
R. BRAND			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE			
FRACTIONS DECIMALS			
FRACTIONS DECIMALS			
ANGLES ± °			
		APICAL INDUSTRIES	REV
		2608 TEMPLE HEIGHTS DR.	A
		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
		SHEETMETAL	
		SIZE: 8 07M26	QWTS: NO. 647.0100
		SCALE: NONE	SHEET 7 OF 6

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REV	DESCRIPTION	DATE	APPROVED



FOR CHART DATA REV. 01-01 DRAWN BY: J. B. BAKER CHECKED BY: J. B. BAKER DRAWING APPROVAL BY: J. B. BAKER DATE: 01-01-01	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS DECIMALS ANGLES IN DEGREES	SHEET: 0006 REV. NO. 647.0100 SCALE: NONE

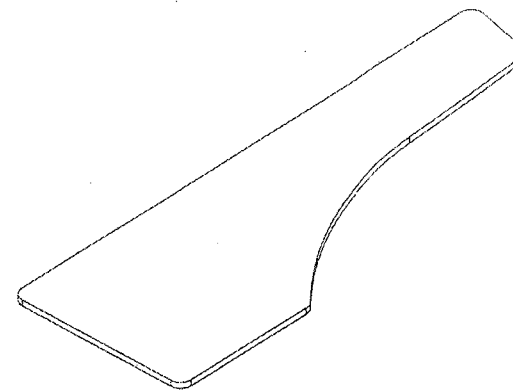
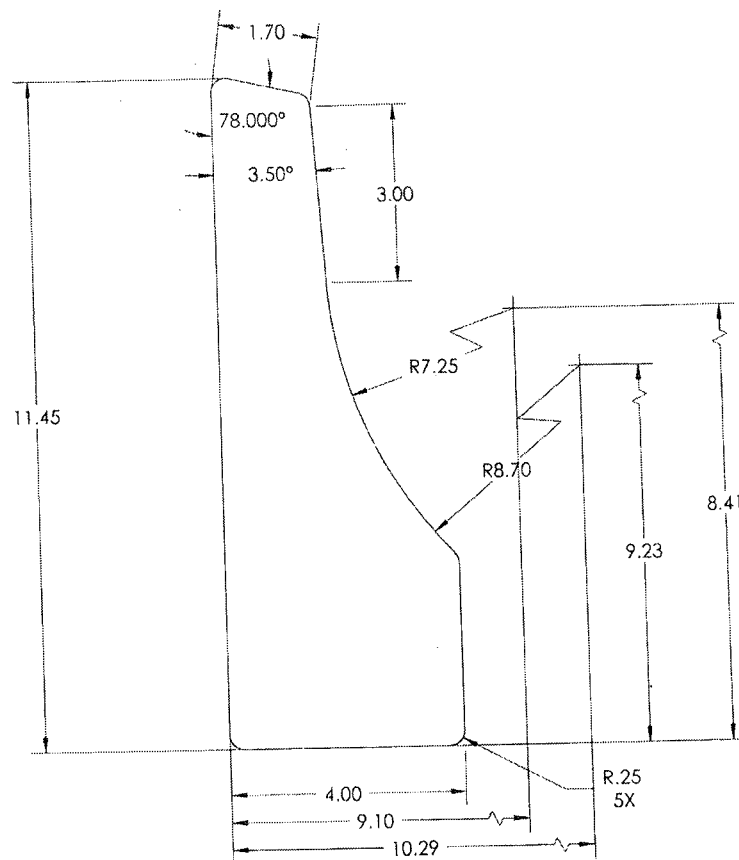
SHEETMETAL

647.0100

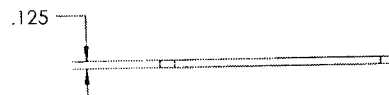
SHEET 3 OF 6

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REV	DESCRIPTION	DATE	APPROVED



647.0113

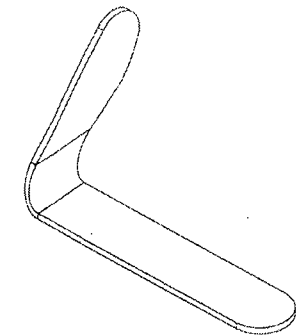
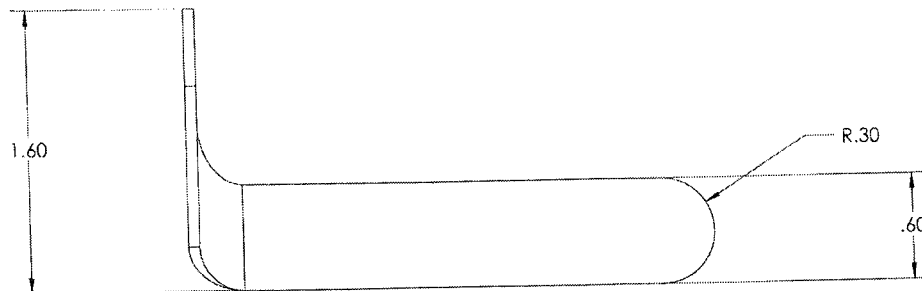


<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		<b>SHEETMETAL</b>	
INFORMATION DESIGNED BY: J. B. BROWN DRAWN BY: J. B. BROWN CHECKED BY: J. B. BROWN DATE: 05/28/07	PART NAME 647.0113	DWG. NO. 647.010J	REV. A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±.01 3 PLACES DECIMALS ±.005 ANGLES ±.5°		SCALE: NONE	

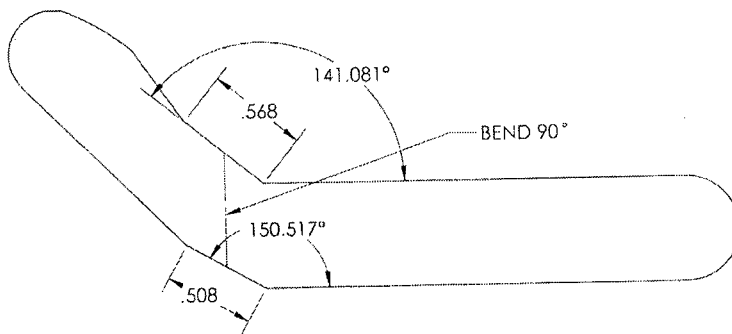
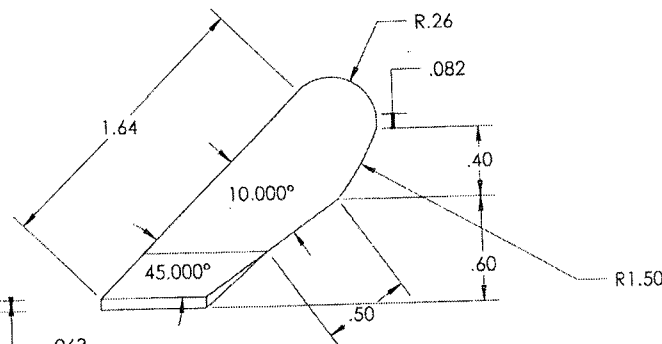
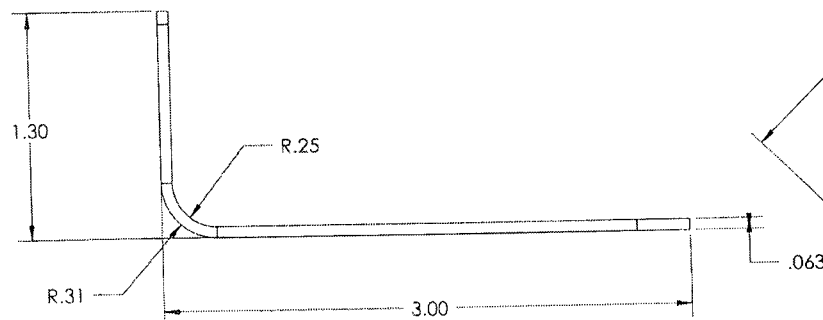
SHEET 4 OF 6

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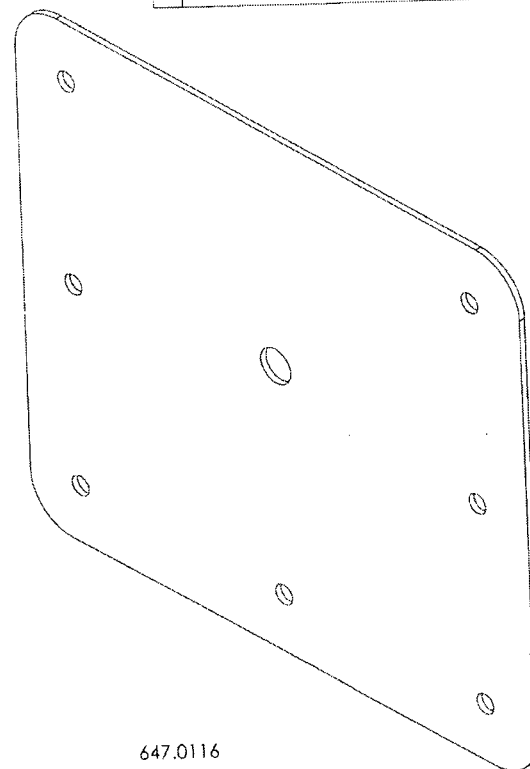
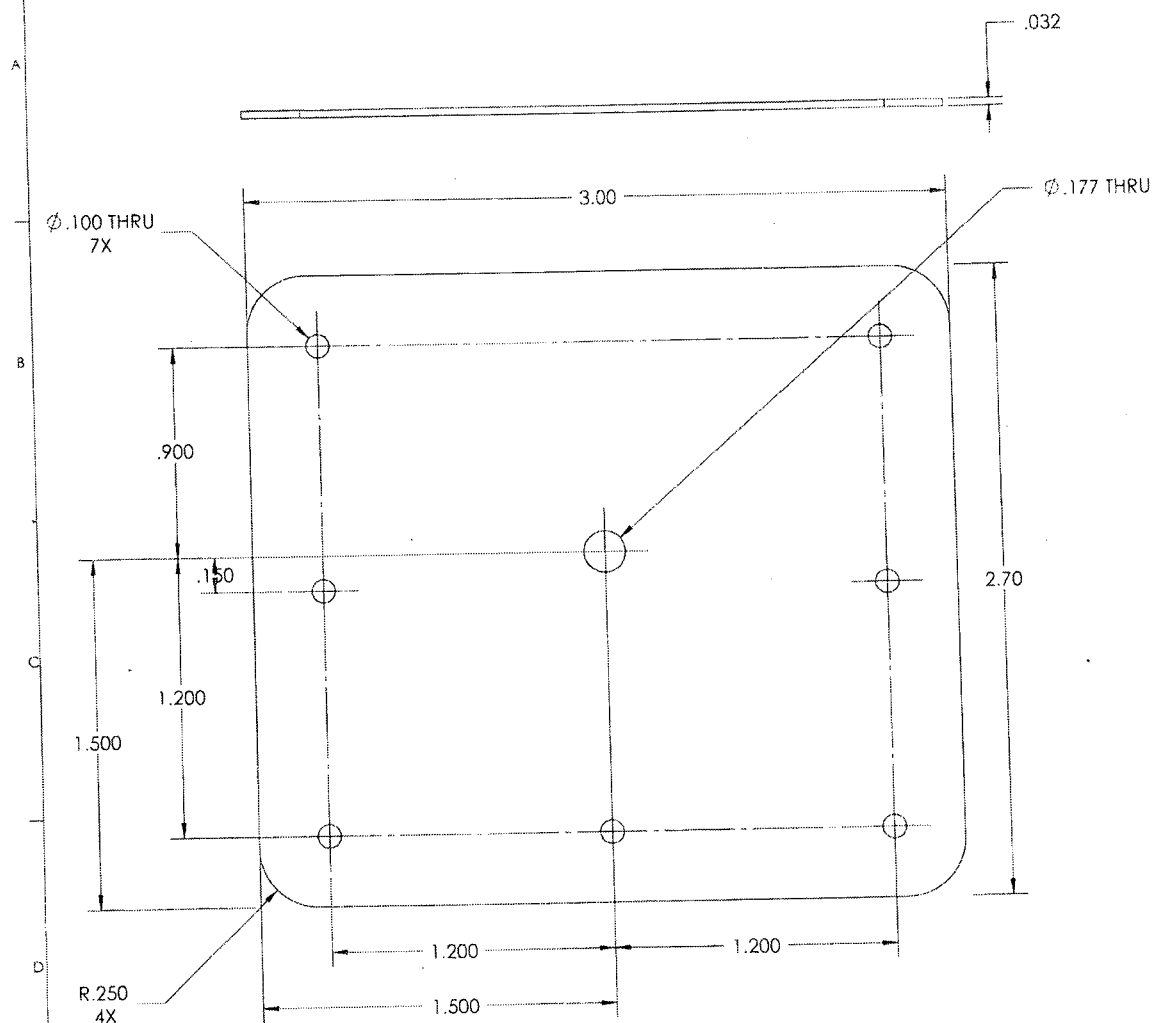


647.0114 SHOWN  
647.0115 OPPOSITE



FLAT PATTERN

ORIGINAL DATE 03/20/00	APICAL INDUSTRIES
DRAWN BY P. ROSAND	2608 TEMPLE HEIGHTS DR.
CHECKED BY P. ROSAND	OCEANSIDE, CA. 92056-3512
DATE 03/20/00	(760) 724-5300
CONTRACTING	SHEETMETAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ANGLES	SIZE CODE B 07/M16
DATE 03/20/00	647.0100
SCALE NONE	SHEET 5 OF 6

[illegible]

647.0116

[illegible]



A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

## Pack List

Number: 63243

Date: 08-Sep-14

To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ship To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140575 PO: PO25574 Line:		
4 ea	Part: 646.3810 BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140576 PO: PO25574 Line:	Rev:	
16 ea	Part: 646.3812 GUSSET BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140577 PO: PO25574 Line:	Rev:	
12 ea	Part: 647.0113 STRUT DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140578 PO: PO25574 Line:	Rev:	
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>8/9/14</u></p> <p>CERTIFIED SIGNATURE : <u>[Signature]</u></p>			



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25574**

Purchase Order Date 8/29/2014

PO Print Date 9/3/2014

Page Number 4 of 5

**Order From :**

VC-ATG001

A.T.G. INDUSTRIES INC.  
731 INDUSTRIELLE ROAD  
ROCKLAND, ON K4K 1T2  
CANADA

**Ship To :** DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 613-446-4544

**Ship To Contact**

**Ship To Phone**

**Ship Via:** VENDOR'S TRUCK

**Ship Acct:**

**Buyer**

Michael Gregoire

**Customer POID**

**Customer Tax #** 10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

FCA - (Free Carrier)

7	122898	646.3812 Gusset Bracket	9/8/2014	16.00	\$6.10	\$97.60
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No  
9/8/2014

per Drawing 646.3812 rev.N/C

Finish: Hard anodize IAW MIL-A-8625 Type 3, Class 2, Color Black

Prime: Cardinal 4860-50 Pretreatment Primer IAW MIL-P-23377J Type 1 Class N

8	117071	647.0113 Strut Doubler	9/8/2014	12.00	\$11.75	\$141.00
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No  
9/8/2014

per Drawing 647.0113 Rev. N/C

Finish: Hard anodize IAW MIL-A-8625 Type 3, Class 2, Color Black

Prime: Cardinal 4860-50 Pretreatment Primer IAW MIL-P-23377J Type 1 Class N

**Line Total:** \$97.60

**Line Total:** \$141.00

**Note:**

9/3/2014